

Date: Tuesday, 25/11/2008 9:53:34 AM
User: Melanie Fauteux

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARPLATE |
| Job Number | : 43723 -2 | Part Number | : D33191 |
| Estimate Number | : 10437 | Drawing Number | : D3319 REV. B |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 25/11/2008 S.O. No. : | Drawing Revision | : B |
| Prsht Rev. | : NC | Material | : |
| First Issue | : / / | Due Date | : 02/12/2008 |
| Previous Run | : 42513 | Type | : SMALL / MED FAB |
| Written By | : | Qty: | Split 7 12 Um: Each |
| Checked & Approved By | : MF 08-11-25 | | |
| Comment | : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC Est Rev: C Now on Waterjet 06-10-26 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|----------------------|
| 1.0 | M1010S18GA | 1010/1025 SHEET .048 |
|-----|------------|----------------------|



8.1



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)

1010/1025/A21/6aA SHEET .048 4.7

Batch: 103089x7 HB 8-11-25

106603 X 3 = 2.1
109948 X 2 = 1.4

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

HB 8-11-25

2-Deburr if necessary

HB 8-11-25

13

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



HB 8-11-25



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

Sosulbas (HB)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

u/n Done at step #22
Solu/25

Date: Tuesday, 25/11/2008 9:53:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43723

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

8308/11/26

(13)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

508/11/26 (43)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: P

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M109560

split hard (7)

EL 8-11-27

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

508/11/27 (47)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/11/27 (47)

11.0

POWDER COATING

POWDER COATING



M109648



(7X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40
320 OF
8:10

M-1

08/11/28

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-28

(47)

Date: Tuesday, 25/11/2008 9:53:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43723

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



TX

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 497

8/11/28

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/08

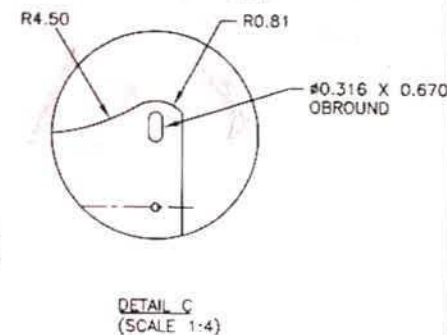
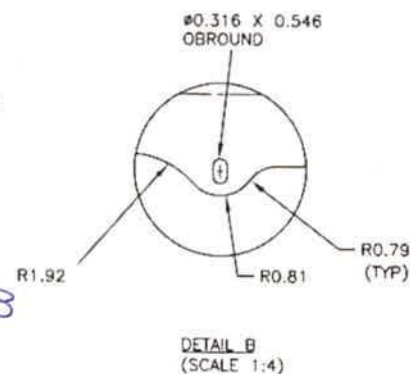
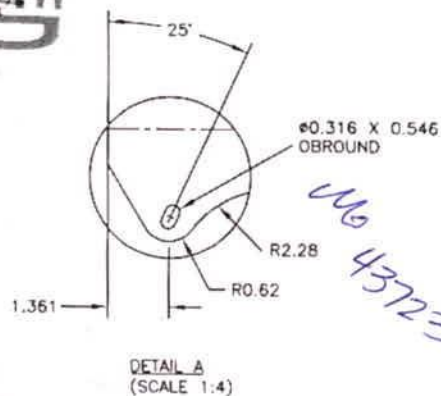
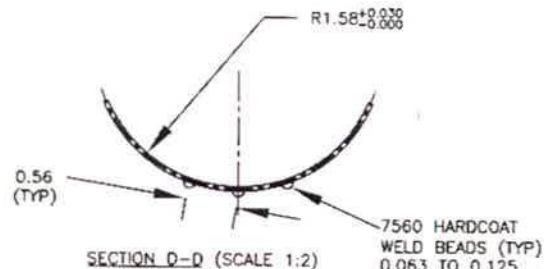
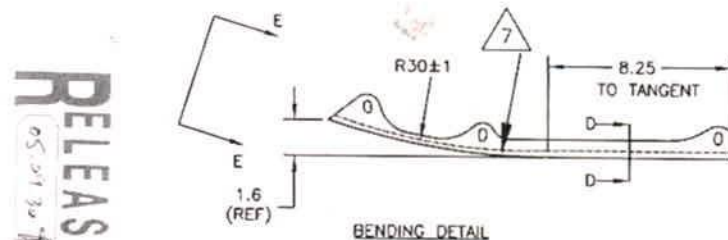
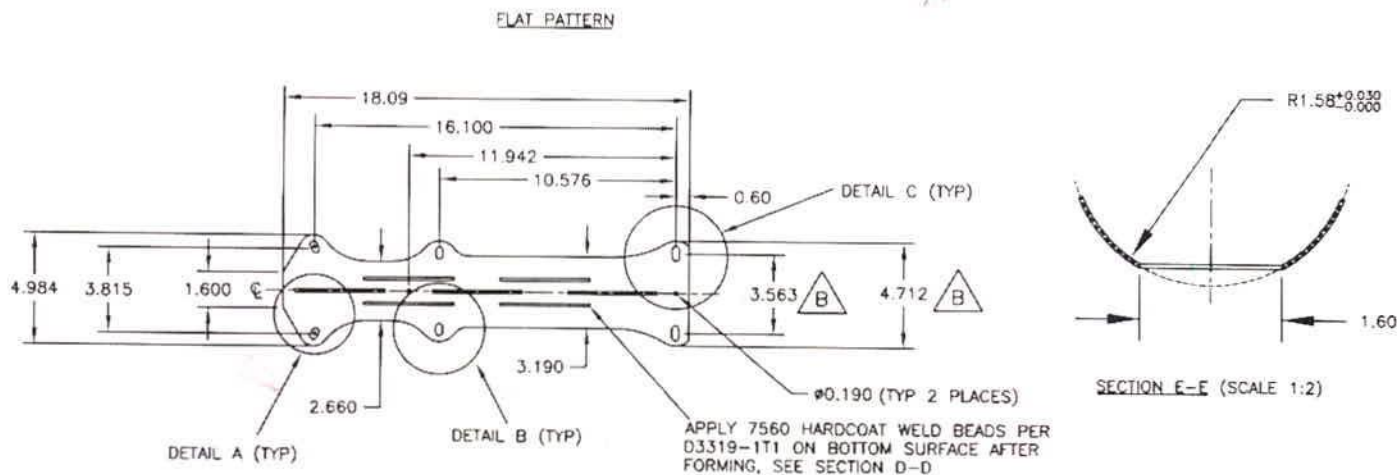
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-28

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|-------------|-------------|------------------------------------|
| P41 | P41 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| [Signature] | [Signature] | D3319 |
| DATE | TITLE | REV. B |
| 05.06.06 | WEARPLATE | SHEET 1 OF 5 |
| A | 04.09.24 | NEW ISSUE |
| B | 05.06.06 | WIDEN HOLES, REDUCE WIDTH -3/-5/-7 |
| | | SCALE 1:8 |

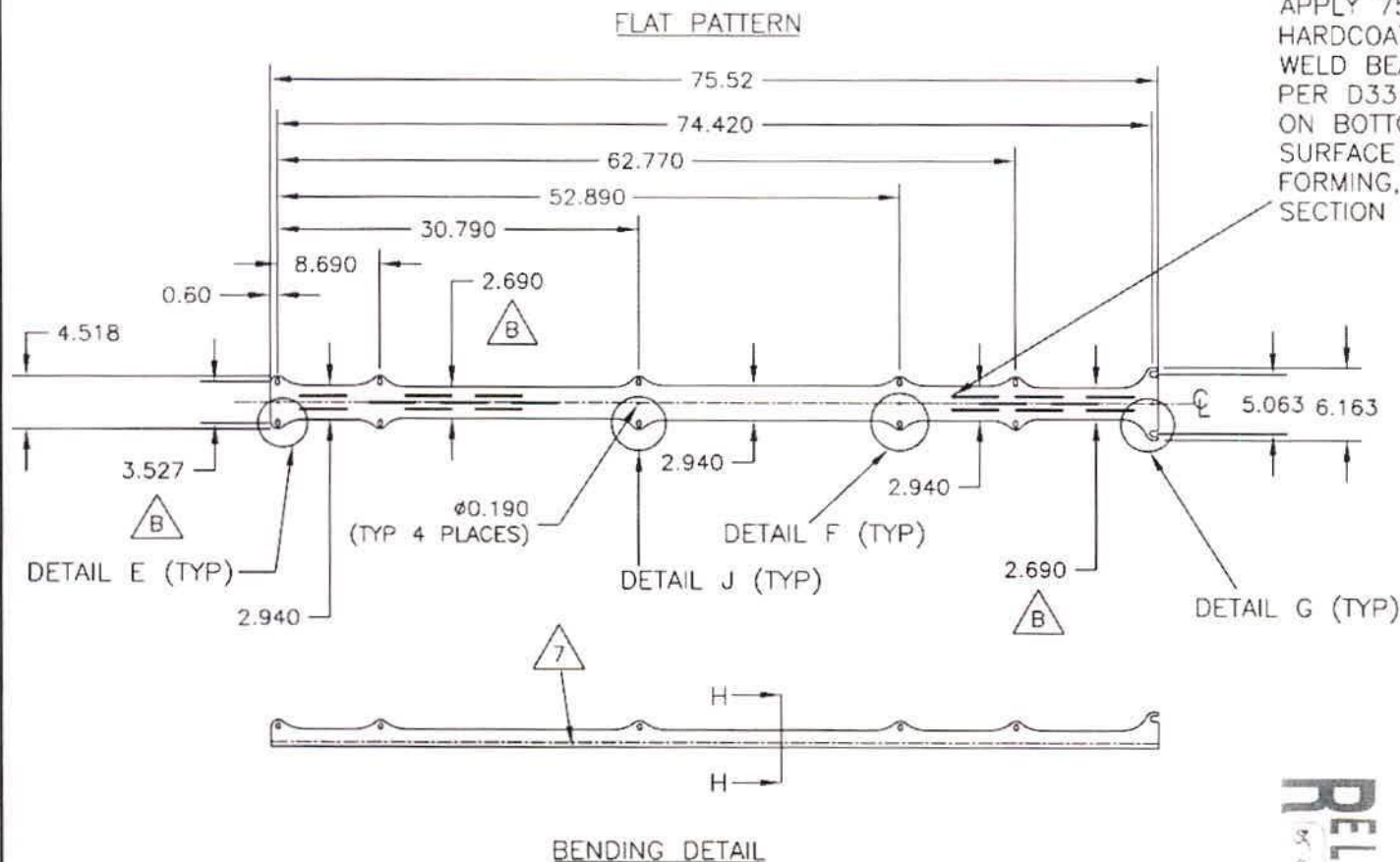
RELEASED
05.07.30

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

| | | | | |
|----------|----------|---|--------------|--------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | | REV. B |
| 64 | 64 | DRAWING NO. | SHEET 2 OF 5 | |
| CHECKED | APPROVED | D3319 | | |
| 11 | 11 | TITLE | WEARPLATE | SCALE |
| DATE | | | | 1:15 |
| 05.06.06 | | | | |

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

RELEASED
85-01-36-16



D3319-3 WEARPLATE

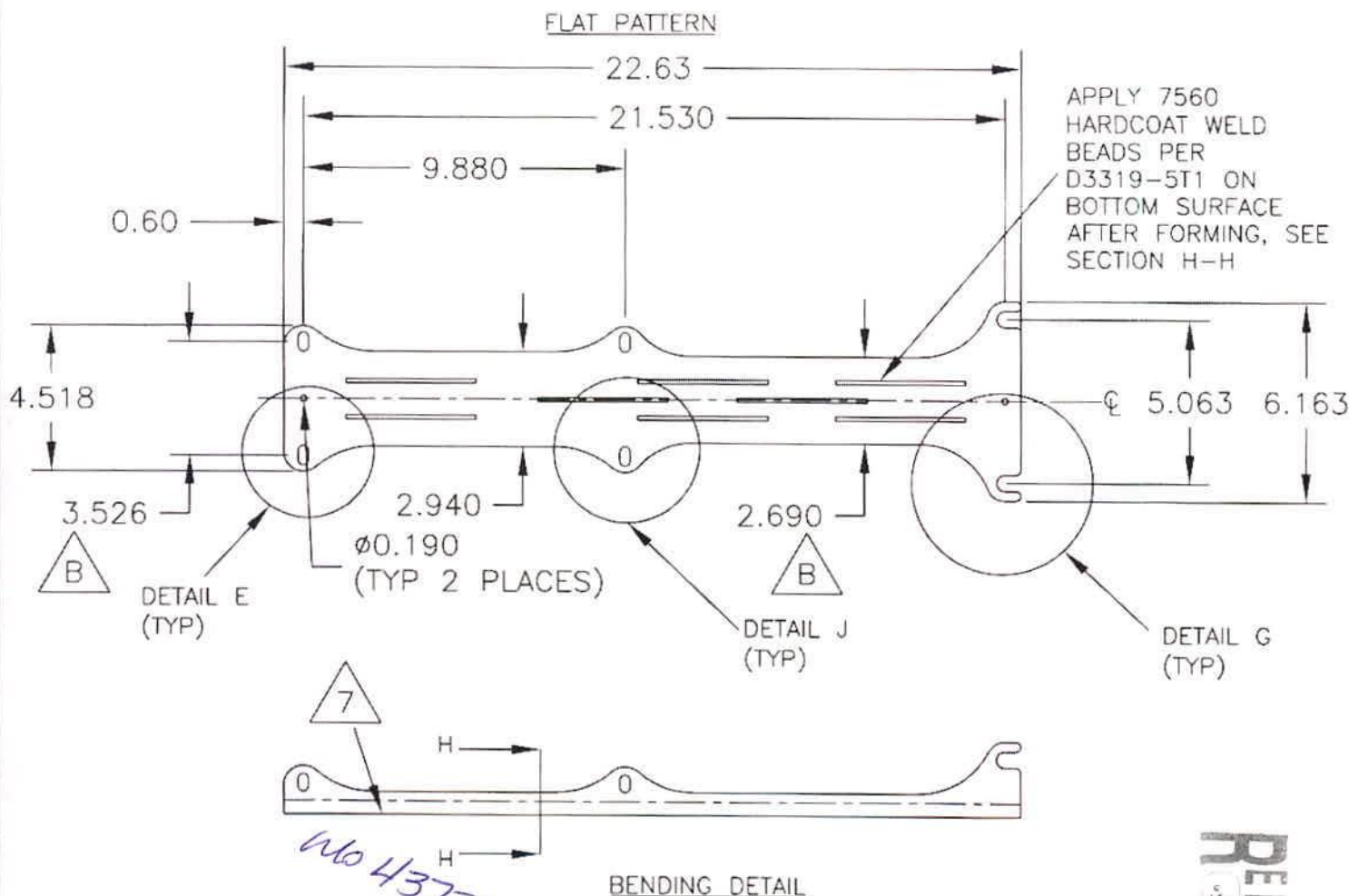
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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Copyright © 2004 by DART AEROSPACE LTD

DART

| | | | | |
|---------|----------|----------|-----------|-----------------------------|
| DESIGN | 941 | DRAWN BY | 941 | DART AEROSPACE LTD |
| CHECKED | # | APPROVED | # | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.06.06 | TITLE | D3319 | REV. B |
| | | | WEARPLATE | SHEET 3 OF 5 |
| | | | | SCALE 1:5 |



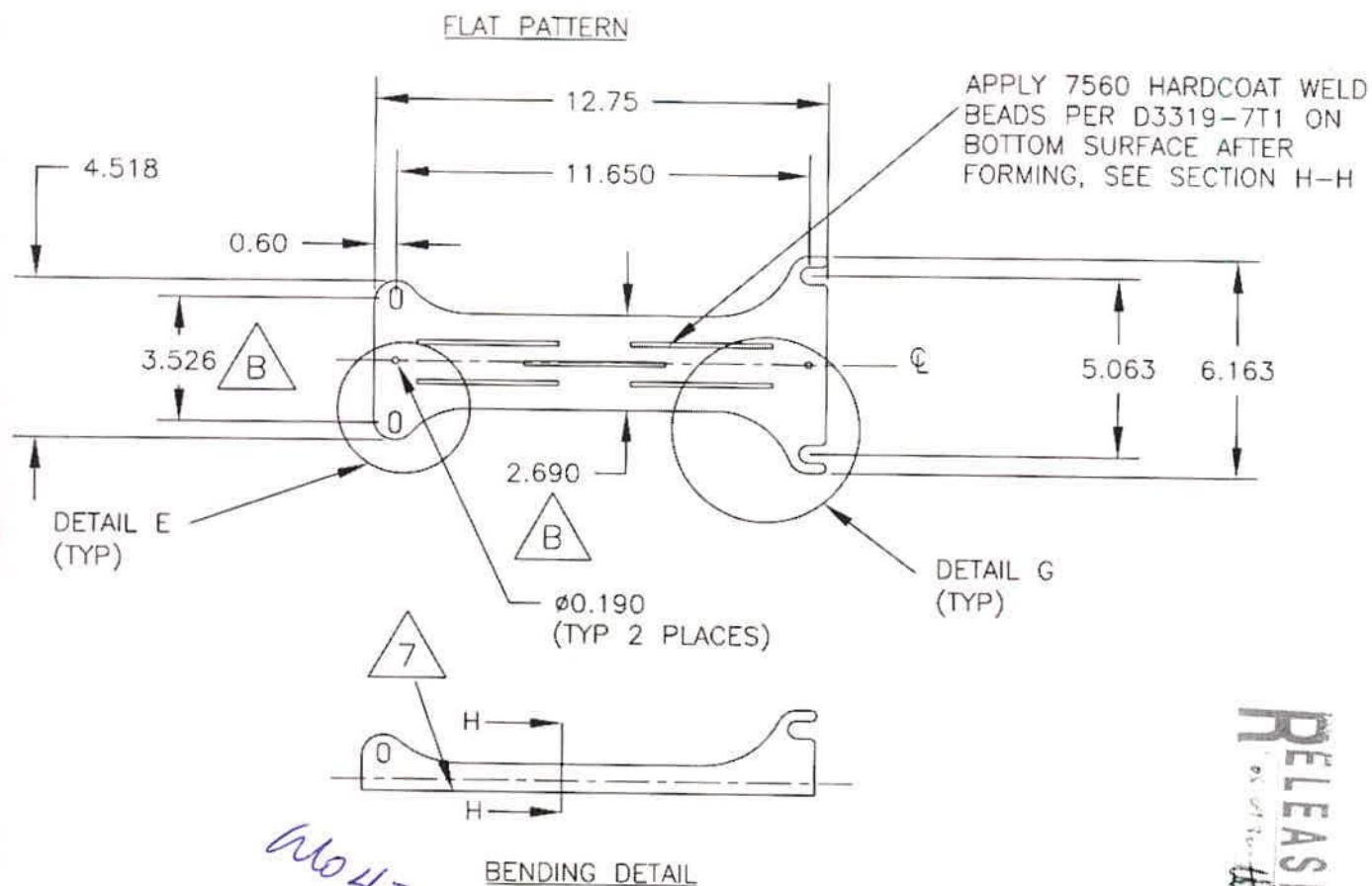
D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

DART

| | | | | |
|---------|----------|-----------|-------|-----------------------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD |
| CHECKED | PH | APPROVED | PH | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.06.06 | TITLE | D3319 | REV. B |
| | | WEARPLATE | | SHEET 4 OF 5 |
| | | | | SCALE 1:5 |



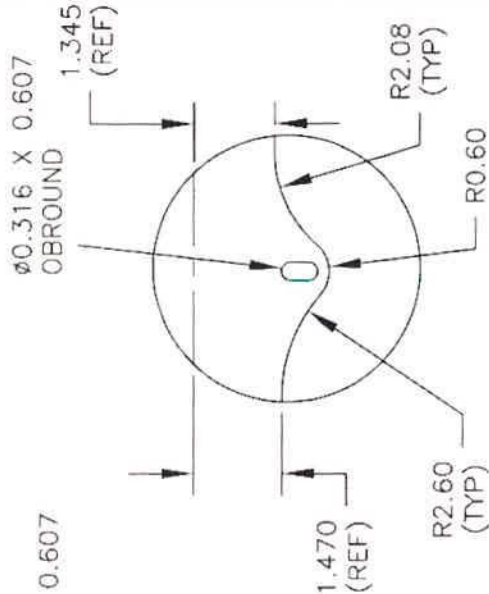
D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

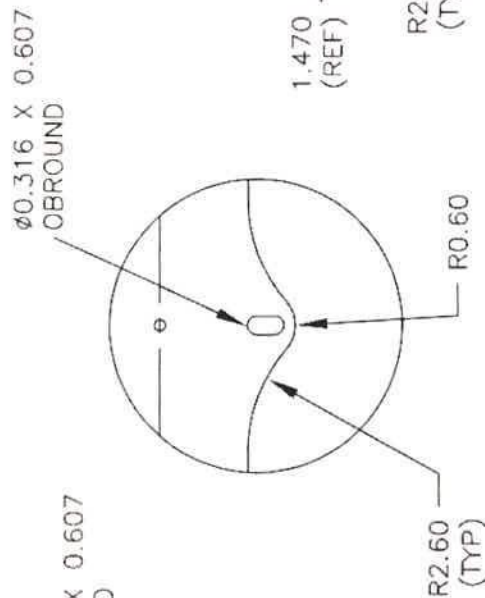
DART

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3319 | REV. B SHEET 5 OF 5 |
| DATE 05.06.06 | TITLE WEARPLATE | | SCALE 1:3 |

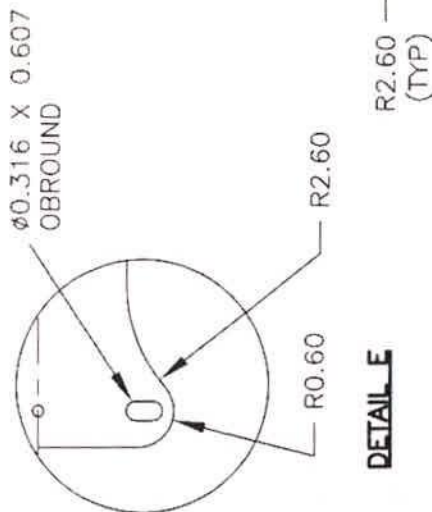
RELEASED
05 01 30



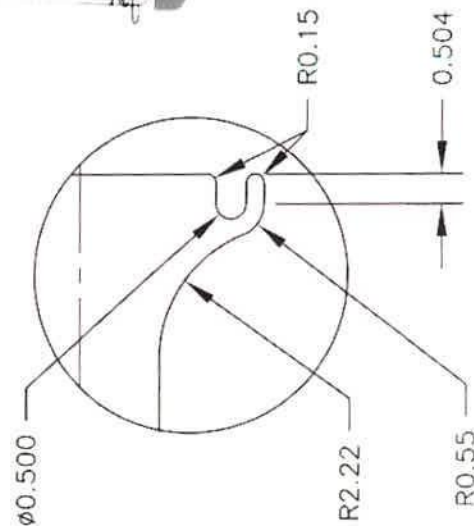
DETAIL J



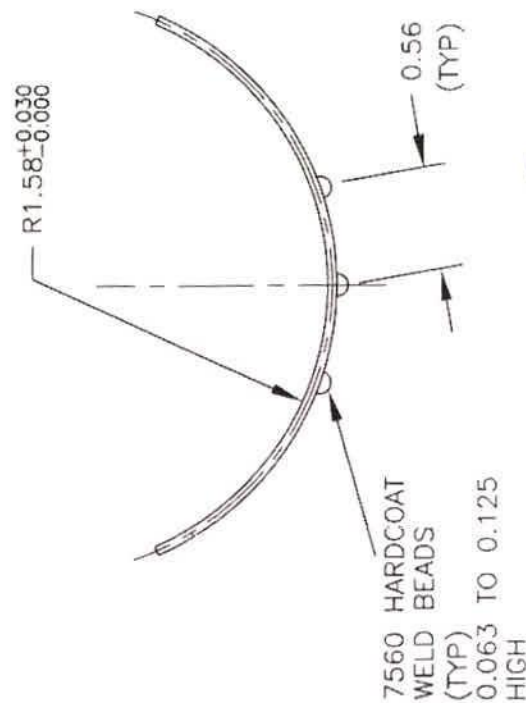
DETAIL F



DETAIL E



DETAIL G



**SECTION H-H
(SCALE 1:1)**

no 43723

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| | | | |
|------------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 43723 |
| Description: Wearplate | | Part Number: | D3319-1 |
| Inspection Dwg: D3319 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| 4.984 | +/-0.010 | 4.988 | X | | | |
| 1.600 | +/-0.010 | 1.606 | X | | | |
| 2.660 | +/-0.010 | 2.668 | X | | | |
| 3.190 | +/-0.010 | 3.193 | X | | | |
| 3.563 | +/-0.010 | 3.564 | X | | | |
| 4.712 | +/-0.010 | 4.708 | X | | | |
| 0.60 | +/-0.030 | .602 | X | | | |
| 10.576 | +/-0.010 | 10.576 | X | | | |
| 11.942 | +/-0.010 | 11.946 | X | | | |
| 18.09 | +/-0.030 | 18.090 | X | | | |
| Ø0.316 x 0.546 | +0.006/-0.001 x +/-0.010 | 318 x 547 | X | | | |
| Ø0.316 x 0.670 | +0.006/-0.001 x +/-0.010 | 318 x 675 | X | | | |
| Ø0.190 | +0.005/-0.001 | .194 | X | | | |
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|-----------------|---------------|---------------------|-----|
| Measured by: HB | Audited by: S | Prototype Approval: | N/A |
| Date: 8-11-25 | Date: 8/16/25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.05.31 | New Issue | KJ/JLM | |